

# Work Order ID 84377

May-10-12 2:36:59 PM

**\*84377\***

Page 1

Item ID: D3119-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Cover Assembly  
 Start Date: 10/05/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 24/05/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3119	Rev B

100	PURCHASING	0.00							
<b>*100*</b>									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>16945</u> D3119-042 Cover Assembly as per Dwg								
	D3119 Supplier: Delastek Material: Cream Kydex 100, 0.060 thick Material								
	release note required								

CL 12/05/10 (1)

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								

R 12/05/28 (1)

120	QC6- Inspect dimensions to drawing	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

8/2/07

SH  
072

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84377

**\*84377\***

Page 2

May-10-12 2:36:59 PM

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>158</u>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

12/14/28 (1)

12/15/29 AJ

MF

12-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-10-12 2:37:03 PM

Page 1

Work Order ID: 84377

**\*84377\***

Parent Item: D3119-042

**\*D3119-042\***

Parent Item Name: Cover Assembly

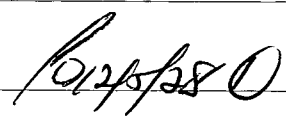
Start Date: 10/05/2012

Required Date: 24/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP: A03.02.24New IssueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3119-042P <b>*D3119-042P*</b> Cover Assembly		Purchased	No			100	Each	0.0000	1	1			
									**				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

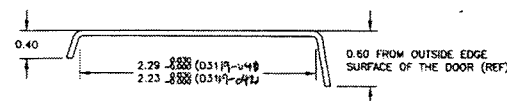
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

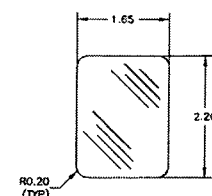
**NOTE:** Date & initial all entries

COPY RELEASE  
04.11.17

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84377 MLC  
12/05/20



SECTION A-A



D3119-3 WINDOW

D3119-1 COVER, LH (SHOWN, REPLACES PREMIER P/N B30-23000-219)

- 1) MAKE FROM TOOL B30-23000-219T
- 2) MATERIAL: CREAM KYDEX 100, 0.060 THICK

D3119-2 COVER, RH (OPPOSITE, REPLACES PREMIER P/N B30-23000-220)

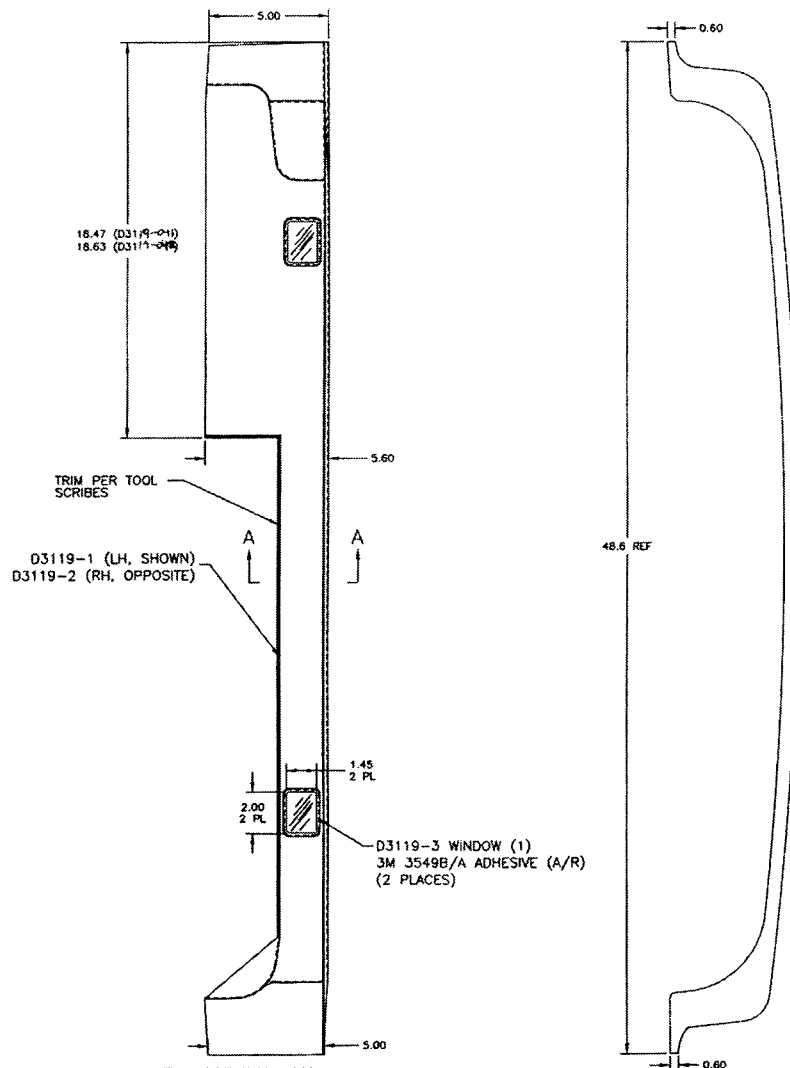
- 3) MAKE FROM TOOL B30-23000-220T
- 4) MATERIAL: CREAM KYDEX 100, 0.060 THICK

D3119-3 WINDOW (REPLACES PREMIER P/N B30-23000-221)

- 5) MATERIAL: LEXAN, 0.060 THICK

GENERAL NOTES

- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



D3119-041 COVER ASSEMBLY, LH  
(SHOWN, REPLACES PREMIER P/N B30-23000-29)  
D3119-042 COVER ASSEMBLY, RH  
(OPPOSITE, REPLACES PREMIER P/N B30-23000-30)

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OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

B	04.11.17	RE-DESIGN
A	02.04.15	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3119
DATE	04.11.17	TITLE COVER ASSEMBLY
		REV. B SHEET 1 OF 1 SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO16945

Purchase Order Date 5/10/12

PO Print Date 5/10/12

Page Number 1 of 1

Order From :

VU-DEL003

DELASTEK INC  
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7  
CA

Contact Name  
Vendor Phone 819 533 5788  
Vendor Fax 819 533 3494  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency USD  
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA



Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3119-042P	Cover Assembly	5/24/12 Yes	1.00 Each	FedEx PI collect	\$105.0000	\$105.0

Special Inst: AS PER DWG D3119 REV. B  
B84377

PO Total: \$105.0

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 5/10/12



DELASTEK Inc.  
2699 5e Avenue  
Local 14, C.P. 10100  
Grand-Mère, Québec G9T 5K7  
Canada  
Tel.: (819) 533-5788  
Fax: (819) 533-3494

# PACKING SLIP

## CERTIFICATE OF COMPLIANCE

Invoice No.	43527
Customer No.	DART US

### Bill To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

### Ship To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
23-05-2012	10-05-2012	20704	Chantal Lavoie	PO16945	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
FEDEX P1 Collect		Point de départ		Claude Lessard, ext. 233	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC135-0002  Szlot26	Line #1 D3119-042 Cover Assy B84377 U of M: Chaque Dwg Rév.: B  No. Lot 27747 1	

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request*

Accepted by:

*[Signature]*  
Quality department

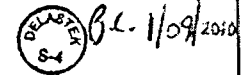
AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Lundi, 2011-04-04 13:04:38  
 Utilisateur: marc dubé

## Feuille de Procédé

 Client : DART US DART AEROSPACE LTD  
 Numéro Job : 27747  
 Numéro Soumission : 4137  
 Numéro B.A. :  
 Cette fois : 2011-04-04 No. B.V. :  
 Prsht Rev. : NC  
 Prem. fois : - - Type :  
 Job précédente : 27121

 Nom Dessin : COVER ASSY  
 Numéro Article : DKC135-0002  
 Numéro Dessin : D3119  
 Projet Numéro : DKC135  
 Révision dessin : B  
 Matériel : Kydex 100 beige .060" Thk  
 Date Dûe : 2011-04-11 Qté: 2 UDM: UNITE

 Écrit par :  
 Vérifié & Approuvé par :  
 Commentaires : N° de pièce Dart Aerospace: D3119-042  
 N° de pièce Delastek Aeronautique: DKA359-0006  
 N° de pièce Delastek Composites: DKC135-0002

 Process Sheet Rév.: 00 Création du premier dans DKA à partir de la  
 Rév.: 03 de DKC

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description:

1.0 AMB0208 Kydex 100 cream 0.060"thick

Commentair Qty.: 0.36 FEUILLE(s)/Unit Total: 1.44 FEUILLE(s)

Kydex 100 cream 0.060"thick

N° de Lot: 1-28/23-1

2.0 SORTIE MATÉRIEL Sortir le matériel du magasin



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Sortir le matériel du magasin

Date: 01/09/10 Sceau:



3.0 THERMOFORMAGE Thermoformage / Découpe primaire



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Thermoformage des pièces.

Monter le set-up du moule de thermoformage N° DKG 359-505 sur le thermoformeur 4' x 8'.

 Tailler le matériel selon les dimensions requises:  
 16" x 62" x .060" Thk.

Thermoformer la pièce B30-23000-220.

Autocontrôle de fabrication. (Visuel et épaisseur)

 Modifier dimension  
 du matériel: 24" x 68" x .060"


B.C. 01/09/2010

Date: , Lundi, 2011-04-04 13:04:38  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 27747

Nom Dessin: COVER ASSY  
Numéro Article: DKC135-0002

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Quantité : 2 Date : 01/09/10 Sceau : 12

Quantité : \_\_\_\_\_ Date : \_\_\_\_\_ Sceau : \_\_\_\_\_

4.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Trimage de finition

Faire le découpage primaire sur la scie à ruban.

Faire le trimage de la pièce selon la ligne tracée sur le moule (elle doit apparaître sur la pièce) et selon le dessin page 21 (Pour les trous).

Autocontrôle de fabrication. (Visuel et selon le moule)

Déburrer.

Quantité : 2 Date : 2.9.10 Sceau : \_\_\_\_\_

Quantité : \_\_\_\_\_ Date : \_\_\_\_\_ Sceau : \_\_\_\_\_

5.0

AMB0209

Lexan 9034 0.060" thickness

Commentair Qty.: 0 POUCE CAR(s)/Unit Total : 0 POUCE CAR(s)

Lexan 9034 0.060" thickness

N° de Lot W/A

6.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Taillage du matériel.

Sur la banc scie, tailler les B30-2300-221 selon les dimensions du dessins (1.65" x 2.20") et faire des rayons de .20" au quatre coins.

Ébavurer.

Autocontrôle de fabrication. (Visuel et selon le dessin)

Quantité : 2 Date : 2.9-10 Sceau : \_\_\_\_\_

Quantité : \_\_\_\_\_ Date : \_\_\_\_\_ Sceau : \_\_\_\_\_

Date: Lundi, 2011-04-04 13:04:38

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: COVER ASSY

Numéro Job: 27747

Numéro Article: DKC135-0002

Numéro Job:



# Séq.: Machine ou Opération: Description :

7.0 AAC0562 3549 B/A adhesive kit 2oz.

Commentaire Qty.: 0.00 UNITE(s)/Unit Total: 0.00 UNITE(s)

3549 B/A adhesive kit 2oz.

N° de Lot:

1-27869-2

8.0 PRÉPARATION. Préparation du matériel



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs

Préparation du matériel.

Faire le mélange de l'adhésif 3549 B/A selon les instructions inscrites sur le contenant.

Date: 2-9-10

Sceau:



9.0 ASSEMBLAGE Assemblage mécanique



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Assemblage général des pièces

Assembler les deux B30-23000-221 Window sur le B30-23000-220 à l'aide de l'adhésif 3549 B/A et laisser sécher pendant 16 heures.

Autocontrôle de fabrication. (Assemblage)

Quantité: 2 Date: 2-9-10 Sceau:



Quantité: Date: Sceau:

10.0 INSPECTION Inspection générale



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Inspection générale

Faire l'inspection de la pièce selon le dessin.

Quantité: 2 Date: 8 sept 10 Sceau:



Quantité: Date: Sceau:

Date: Lundi, 2011-04-04 13:04:38  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 27747

Nom Dessin: COVER ASSY  
Numéro Article: DKC135-0002

Numéro Job:



# Séq.: Machine ou Opération: Description:

11.0

IDENTIFICATION

Identification à encre indélébile



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Identification des pièces.

Faire l'identification : N° de pièce : D3119-042

Date de fabrication : \_\_\_\_\_

N° de Work Order: \_\_\_\_\_

Sceau d'inspection

**D3119-042**

**SEP 08 2010**

**#27747**

Autocontrôle de fabrication. (Visuel de l'identification)

Quantité : 2

Date : 8/09/10

Sceau : 14

*SP FORMATION*

Quantité : 2

Date : 9 Sept 10

Sceau : SP

12.0

EMBALLAGE

Emballage & Entreposage



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballage & Entreposage

Emballer les pièces individuellement dans un sac en polythène et entreposer au besoin en attendant la livraison vers le client.

Quantité : 2

Date : 9 Sept 10

Sceau : SP

Quantité : \_\_\_\_\_

Date : \_\_\_\_\_

Sceau : \_\_\_\_\_